

503

W/O SPLIT

DART AEROSPACE LTD	Work Order:	22033B
Description: Bracket	Part Number:	D3264-1
Dwg: D3264 Rev. A	Qty:	15 11

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JH	04.12.08	15
2	MV	Cut blanks: 4.500" x 1.250" x 5.700" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1	EP	04.12.16	11
3	MV	Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1	ML/EP	04.12.20	11
4	QC2	Inspect parts as they come off the CNC machine	ML/EP	04.12.20	11
5	QC8	Second check	EL	05.03.02	11
6	MV	Deburr	ML	05.02.25	11
7	QC5	Inspect work to Step 6	EL	05.03.02	11
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.03.03	11
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05.03.03	11
10	QC3	Inspect Powder Coat	CD	05.03.04	11
11	ST	Identify and Stock <i>Identify with part; Brackets Joint Aeing Don't PERMANENT MARKER.</i>	CD	05.03.04	11
12	AC	Cost / part <u>\$8.95</u>	SAC	05.03.08	11
13	DC	Close W/O <u>29.35</u> Inspect Level 21	JH	05.03.08	11

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature]

144.78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22033
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.687	/		vern	
0.063	+/-0.010	0.061	/		vern	
0.125	+/-0.010	0.130	/		mic	
0.875	+/-0.010	0.877	/		mic	
0.062	+/-0.010	0.068	/		vern	
R0.03	+/-0.030	0.030	/		R.g	
R0.13	+/-0.030	0.125	/		R.g	
1.00	+/-0.030	1.000	/		mic	
0.125	+/-0.010	0.125	/		mic	
0.600	+/-0.010	0.601	/		vern	
R0.38	+/-0.030					cannot find dim
4.000	+/-0.005	4.004	/		vern	
0.750	+/-0.010	0.754	/		vern	
-0.208	+0.005/-0.000	0.194	/		vern	
Ø0.194						
5.50	+/-0.030	5.505	/		vern	
1.27	+/-0.030					cannot find dim
0.125	+/-0.010	0.127	/		mic	
0.063	+/-0.010	0.067	/			
R0.25	+/-0.030	0.250	/		R.g	
4.27	+/-0.030	4.272	/			
R0.30	+/-0.030	0.30	/		R.g.	

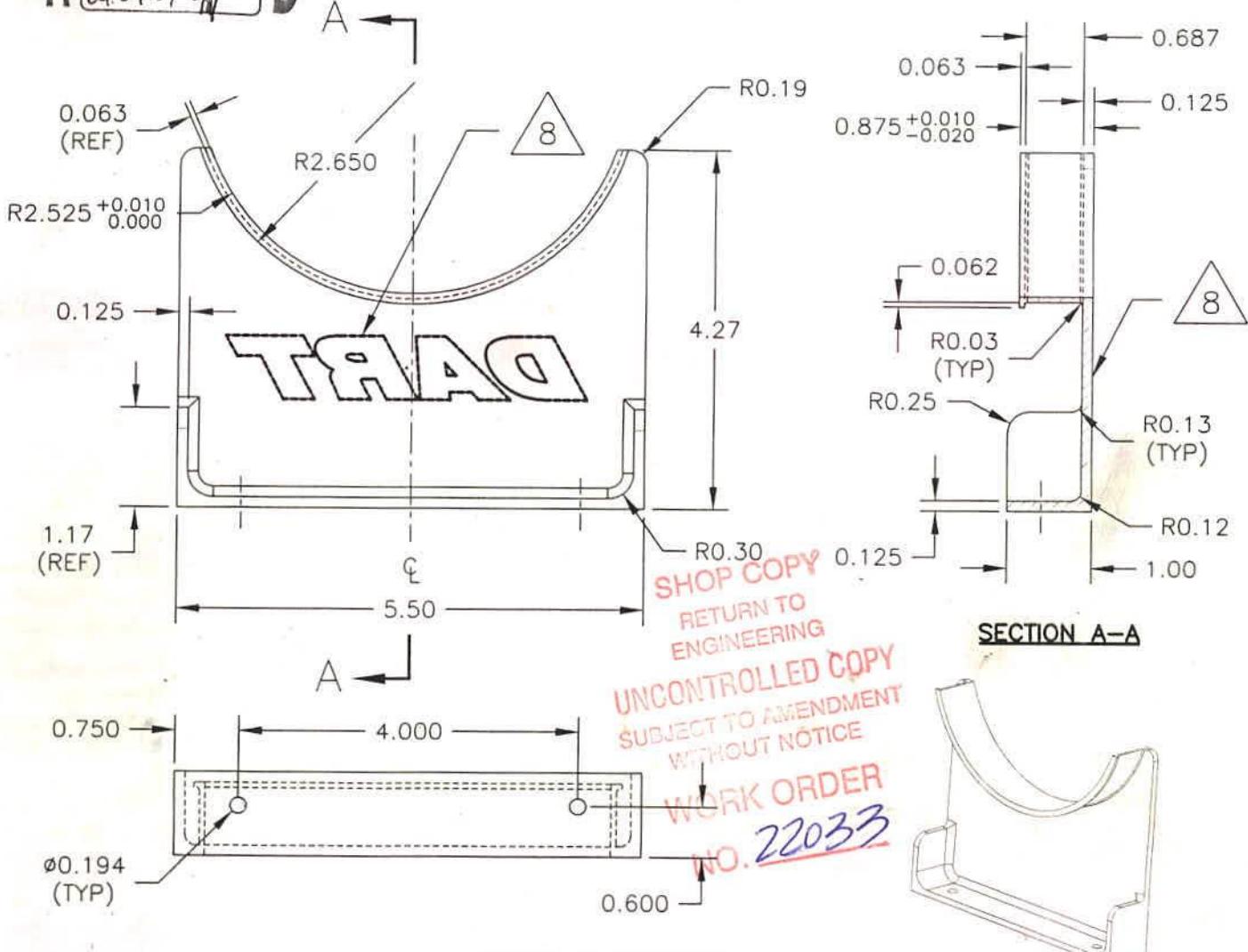
Measured by:	EP	Audited by:	E	Prototype Approval:	N/A
Date:	04.12.20	Date:	04.12.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	

RELEASED
04.07.09

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09 **D3264-1 BRACKET**D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No	:	0022033	Department Code:	
Project Name	:	D3264-1	Burden Flags	: NNNNNNN
Project For	:	WK503	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3264-1	Invoice Number	:
Description	:	Bracket	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	15	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	12-03-04	Est Margin	: 0.000%
Est Finish Date	:	01-15-05	Actual Margin	: 0.000%
Act Finish Date	:			
Drawings Rqrd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00